

5/32


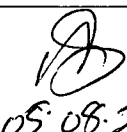
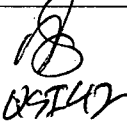
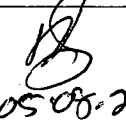
DART AEROSPACE LTD	Work Order:	23822
Description: Ø2.750 Support	Part Number:	D2893-1
Dwg: D2893 Rev. A1	Qty:	20
Page 1 of 1		


Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller. Blank size makes (2) D2893-1 Dwg not required	AF	05.07.15	22
2	PG	Issue P/O: <u>USE STOCK B 23232</u> Description: D6104-005 Material: 17-4 PH SS (AMS 5643 OR AISI 630) as per Dwg D6104 Material release note required.			
3	RG	Receive and inspect for raw material dimensions. Ensure material release note is attached.	N/A		
4	MS	Turn blank for Haas as per Folio FA081	JG	05/08/11	22
5	QC1	Inspect all dimensions as per Dwg D2893	JG	05/08/13	22
6	MV	Machine as per Folio FA081	Er	05/08/22	20
7	MV	Tumble & Deburr	Er	05/08/22	20
8	QC1	Inspect all dimensions to inspection sheet as per Dwg D2893	Er	05/08/22	20
9	QC8	Inspect dimensions for second check	Er	05/08/22	20
10	FP	Powder Coat White (4.3.5.2) per QSI 005 4.3	MM	05 08 24	10
11	QC3	Inspect Powder Coat	DL	05/08/24	20
12	ST	Identify and stock	DL	05/08/24	20
13	AC	Cost / part <u>96.89</u>	Sur	05.08.25	20
14	DC	Close W/O <u>109.54</u> Inspect Level 21	DD	05/09/25	20

Rev	Date	Change	Revised By	Approved
A	01.01.08	Preliminary Issue	EC	
B	01.07.19	Heat treat removed	NG	
C	02.11.26	Reformat; Added P/O	KJ	

RELEASED
02.11.29 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05.08.19	6	- 1 part moved on jig "not tight enough" - holes are not aligned		destroy piece	en 05/08/22	 05.08.22	 05.08.22	 05.08.22

Part No: D283-1 PAR #: 132 Fault Category: HTA NCR: Yes ☐ No ☒ DQA:  Date: 05/08/25

NOTE: Date & initial all entries

Production / Mfg Pass' med QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order: 23822
Description: Ø2.750 Support	Part Number: D2893-1 -
Inspection Dwg: D2893 Rev. A1	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2893 Rev A1/DSK078 Rev A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
Lathe Section									
A	2.707	2.712		2.702	2.712	2.711	2.712		
B	4.946	4.966		4.952	4.951	4.950	4.950		
C	3.064	3.084		3.074	3.075	3.075	3.074		
D	0.718	0.738		0.725	0.726	0.727	0.726		
E	0.090	0.110		0.098	0.098	0.099	0.098		
F	2.934	2.954		2.944	2.944	2.944	2.944		
G	2.166	2.186		2.171	2.173	2.171	2.172		
H	3.890	3.910		3.900	3.900	3.900	3.900		
I	0.914	0.934		0.924	0.928	0.927	0.927		
J	0.022	0.042		0.032	0.032	0.032	0.032		
K	0.109	0.129		0.117	0.117	0.117	0.118		
L									
HAAS Section									
AA	2.985	3.005		2.992	2.997	2.996	2.996		
AB	0.440	0.460		.450	.450	.450	.450		
AC	0.125	0.160		.145	0.146	0.148	0.149		
AD	0.040	0.060		.045	0.042	0.042	0.042		
AE	0.188	0.193	DT8706						
AF	0.125	0.160		.145	0.140	0.143	0.143		
AG	0.140	0.160		.144	0.145	0.147	0.144		
AH	1.360	1.400		1.375	1.380	1.378	1.380		
AI	0.040	0.060		.051	0.050	0.050	0.050		
AJ	1.190	1.230		1.220	1.221	1.221	1.221		
AK	0.010	0.020		.010	.010	.010	.010		
AL	0.053	0.073		.063	.063	.063	.063		
AM	0.240	0.260		.250	.250	.250	.250		
AN	2.518	2.538		2.528	2.528	2.528	2.528		
AO	84.39	90.39	DT8699						
AP	0.257	0.262	DT8683						
AQ	0.053	0.073		.063	.063	.063	.063		
AR									
AS									
Accept/Reject									

Measured by:	J. G
Date:	05/08/13 / 05/08/21

Audited by:	mf
Date:	05/08/22

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	RF

RELEASED
03.07.01

DART AEROSPACE LTD		Work Order:	23822
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893 Rev. A1		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2893 Rev A1/DSK078 Rev A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	26	37	48	By	Date
Lathe Section									
A	2.707	2.712		2.712	2.711	2.710	2.709		
B	4.946	4.966		4.951	4.950	4.949	4.950		
C	3.064	3.084		3.074	3.075	3.076	3.076		
D	0.718	0.738		0.728	0.726	0.731	0.726		
E	0.090	0.110		0.098	0.098	0.100	0.098		
F	2.934	2.954		2.945	2.944	2.945	2.946		
G	2.166	2.186		2.171	2.172	2.170	2.169		
H	3.890	3.910		3.900	3.900	3.900	3.900		
I	0.914	0.934		0.924	0.925	0.930	0.930		
J	0.022	0.042		0.032	0.032	0.032	0.032		
K	0.109	0.129		0.117	0.118	0.116	0.117		
L									
HAAS Section									
AA	2.985	3.005		2.996	2.996	2.996	2.998		
AB	0.440	0.460		0.450	0.450	0.450	0.450		
AC	0.125	0.160		0.143	0.143	0.148	0.145		
AD	0.040	0.060		0.045	0.046	0.049	0.045		
AE	0.188	0.193	DT8706	0.188	0.188	0.188	0.188		
AF	0.125	0.160		0.142	0.147	0.148	0.148		
AG	0.140	0.160		0.146	0.146	0.146	0.147		
AH	1.360	1.400		1.381	1.380	1.381	1.380		
AI	0.040	0.060		0.045	0.045	0.045	0.050		
AJ	1.190	1.230		1.218	1.218	1.220	1.217		
AK	0.010	0.020		0.015	0.015	0.015	0.015		
AL	0.053	0.073		0.063	0.063	0.063	0.063		
AM	0.240	0.260		0.250	0.250	0.250	0.250		
AN	2.518	2.538		2.528	2.528	2.528	2.528		
AO	84.39	90.39	DT8699						
AP	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		No need to Measure with
AQ	0.053	0.073		0.063	0.063	0.063	0.063		
AR									
AS									
Accept/Reject									

Measured by:	J. G. / Er
Date:	05/08/13 / 05/08/22

Audited by:	gml
Date:	05/08/22

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF RE	#

RELEASED
03.07.01

DART AEROSPACE LTD		Work Order:	23822
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893 Rev. A1		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2893 Rev A1/DSK078 Rev A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	$\frac{1}{8}$	$\frac{2}{10}$	$\frac{3}{16}$	$\frac{4}{12}$	By	Date
Lathe Section									
A	2.707	2.712		2.710	2.711	2.711			
B	4.946	4.966		4.953	4.955	4.956			
C	3.064	3.084		3.074	3.074	3.075			
D	0.718	0.738		0.728	0.728	0.724			
E	0.090	0.110		0.100	0.100	0.098			
F	2.934	2.954		2.947	2.946	2.945			
G	2.166	2.186		2.167	2.171	2.171			
H	3.890	3.910		3.898	3.900	3.899			
I	0.914	0.934		0.924	0.924	0.928			
J	0.022	0.042		0.032	0.032	0.032			
K	0.109	0.129		0.117	0.118	0.117			
L									
HAAS Section									
AA	2.985	3.005		2.996	2.995				
AB	0.440	0.460		0.450	0.450				
AC	0.125	0.160		0.146	0.146				
AD	0.040	0.060		0.047	0.043				
AE	0.188	0.193	DT8706	0.188	0.188				
AF	0.125	0.160		0.146	0.147				
AG	0.140	0.160		0.148	0.143				
AH	1.360	1.400		1.379	1.380				
AI	0.040	0.060		0.050	0.050				
AJ	1.190	1.230		1.220	1.221				
AK	0.010	0.020		0.010	0.010				
AL	0.053	0.073		0.063	0.063				
AM	0.240	0.260		0.250	0.250				
AN	2.518	2.538		2.528	2.528				
AO	84.39	90.39	DT8699						
AP	0.257	0.262	DT8683	0.257	0.257				
AQ	0.053	0.073		0.063	0.063				
AR									
AS									
Accept/Reject									

Measured by:	J.G.
Date:	05/08/13 / 05/08/12

Audited by:	J.M.
Date:	05/08/12

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	RF

RELEASED
03.07.01

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jul 14, 2005
03:52 pm

Work Order No : 0023822
Project Name : D2893-1
Project For : WK532
Work Order Type : Main
Main WO Number :
House Part Number : D2893-1
Description : Support
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 07-14-05
Est Finish Date : 08-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00